

Split

Work Order ID 74940-2

\*74940\*

Page 1

Thursday, October 13, 2011 1:13:39 PM

Item ID: D3805-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly Fwd, Low Gear

Start Date: 10/13/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan:

Date: 11-10-13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3805

B

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1-weld D3806-1 to D3805-1 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M117659

E119060 -> 2051B Hardface.

2-Transfer drill holes in bar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Quality Control

Memo

0.00

11-10-18

x812/11-10-18



# Work Order ID 74940

\*74940\*

Page 2

Thursday, October 13, 2011 1:13:39 PM

Item ID: D3805-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate Assembly Fwd. Low Gear  
 Start Date: 10/13/2011 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 10/19/2011 Req'd Qty: 8.00 \*8\* Customer:

## Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
*130*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:00								
	OVEN TEMPERATURE: 320 F								
	FINISH TIME: 8:30								
140	QC3- Inspect Part Finish	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

8X 4 M-L 11/10/19

8 BL 11/10/19



# Work Order ID 74940

\*74940\*

Page 3

Thursday, October 13, 2011 1:13:39 PM

Item ID: D3805-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 10/13/2011 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

150

0.00

\*150\*

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg  
BATCH: 4115230

8 11/10/19

(7)

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

8 11/10/19

(42)

170

Identify as per dwg & Stock Location: FR-1

0.00

\*170\*

Packaging

Memo

0.00

Packaging

x2  
measured  
& counted

4 11/10/19





**Work Order ID 74940****\*74940\***

Page 4

Thursday, October 13, 2011 1:13:39 PM

Item ID: D3805-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 10/13/2011 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

11/10/19  
WF  
11-10-19





# Picklist Print

Thursday, October 13, 2011 1:13:43 PM

Page 1

Work Order ID: 74940

\*74940\*

Parent Item: D3805-041

\*D3805-041\*

Parent Item Name: Wearplate Assembly Fwd, Low Gear

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3805-1

Manufactured

No

100

Each

9.0000

1

8

\*D3805-1\*

Plate

\*\*

Location

WA

75086 x 8

Loc Qty

9

Loc Code

74048

9

~~11-10-18~~ 11-10-18

D3806-1

Manufactured

No

100

Each

24.0000

1

8

\*D3806-1\*

Bar

\*\*

EL 11-10-17

Location

WA

Loc Qty

24

Loc Code

74052

4

74053

20

8

D3807-1

Manufactured

No

150

Each

21.0000

1

8

\*D3807-1\*

Gasket

\*\*

ES 11/10/19

2

Location

FP010

Loc Qty

21

Loc Code

69022

2

74056

19

2



8

7

6

5

4

3

2

1

D3805-041 FWD WEARPLATE ASSY, LOW GEAR

D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

D3805-045 AFT WEARPLATE ASSY, LOW GEAR

D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

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 WITH OPERATIVE  
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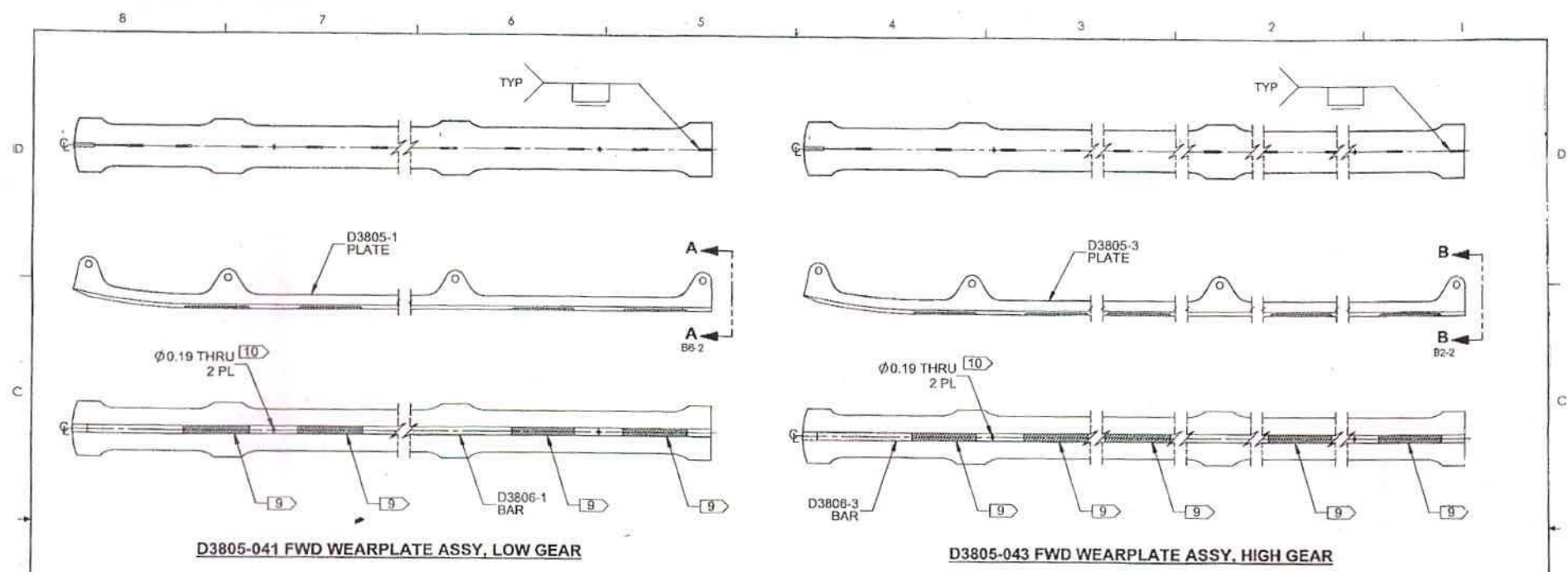
74820 M L 3  
 11/10/13  
 74940

RELEASED  
 2011-10-03  
 MB

B	REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>g</i>		
CHECKED	<i>g</i>	DRAWING NO.	REV. 3
MFG. APPR.	<i>M</i>	D3805	SHEET 1 OF 8
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	WEARPLATE ASSY	N.T.S.
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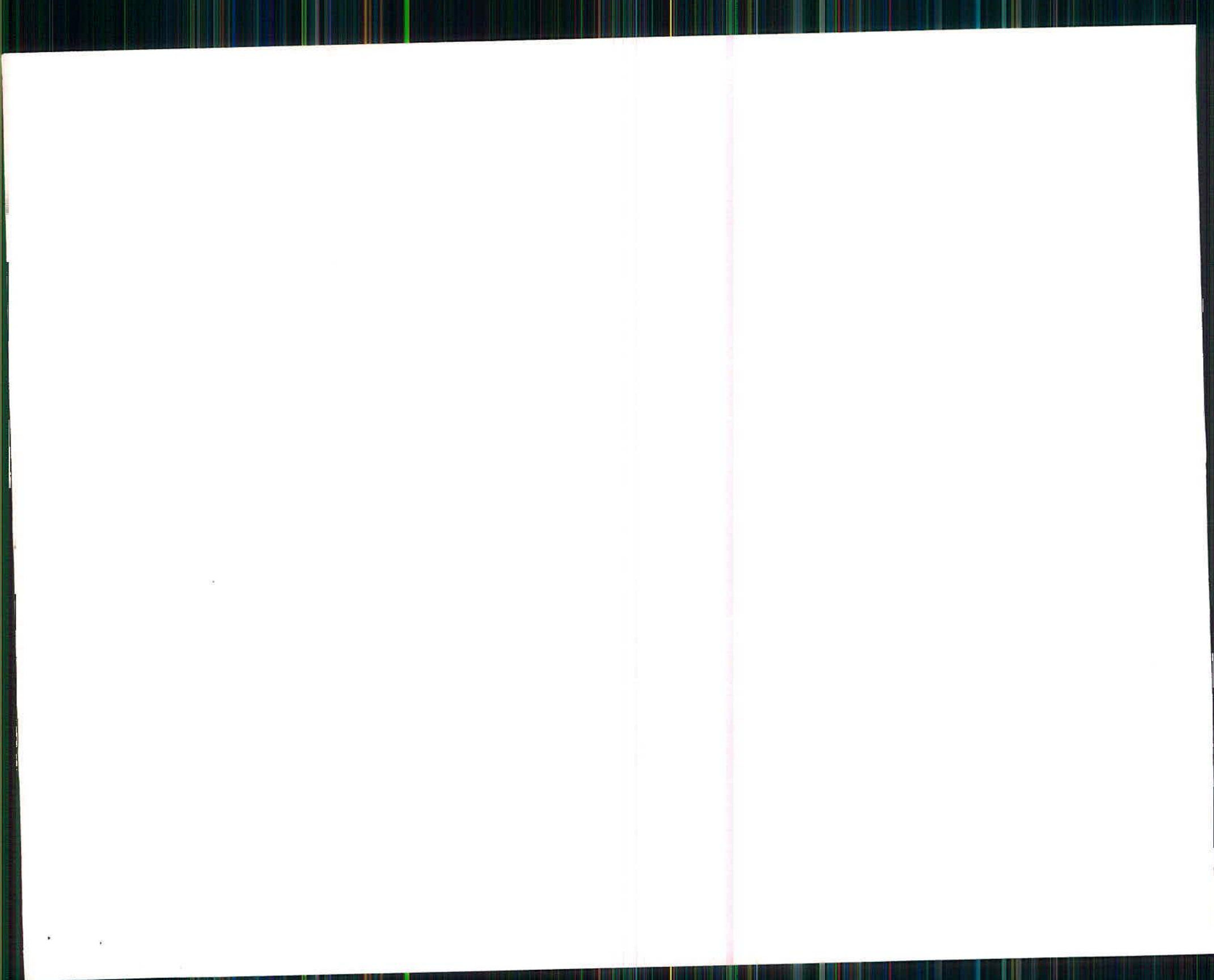


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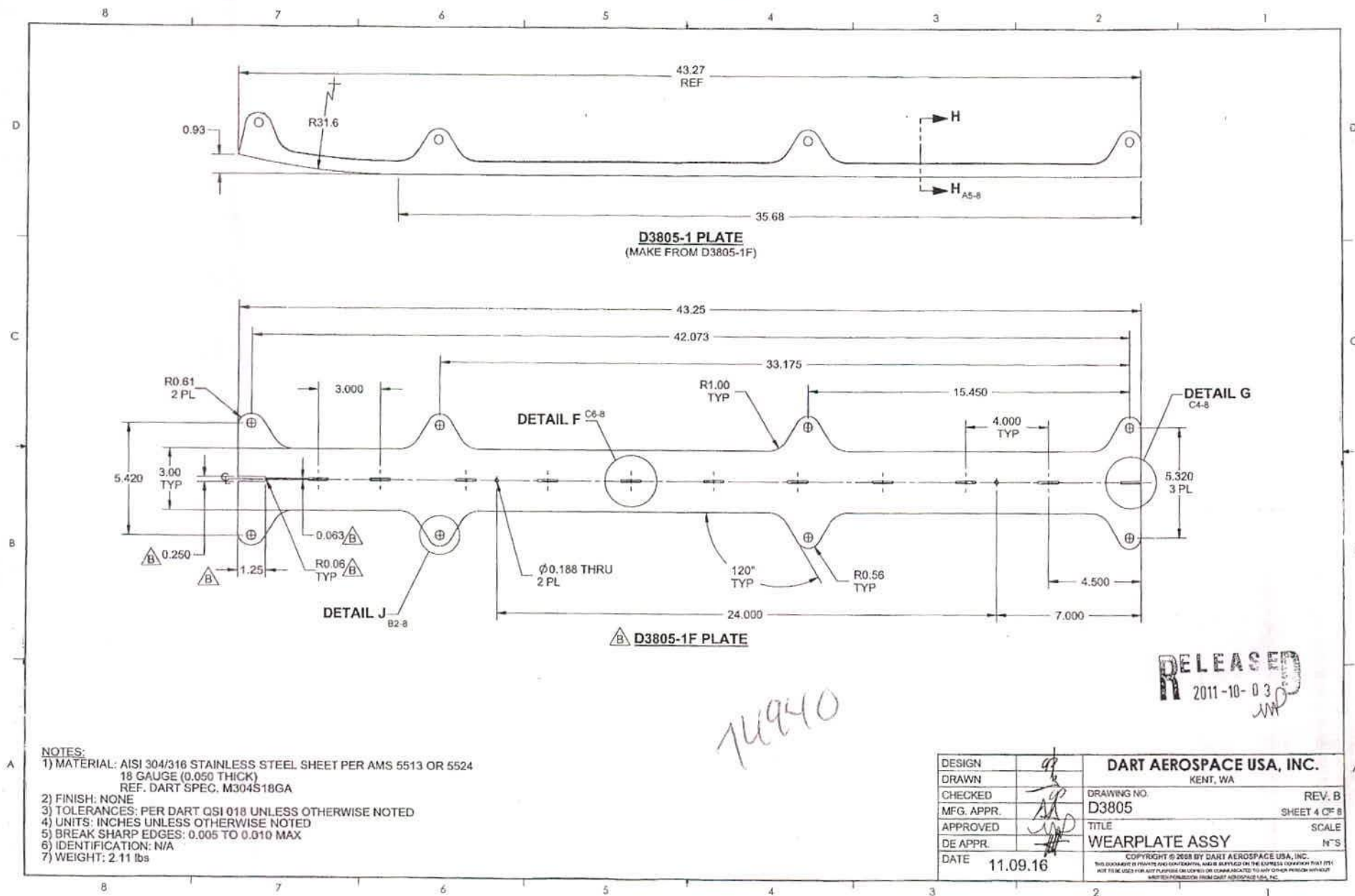
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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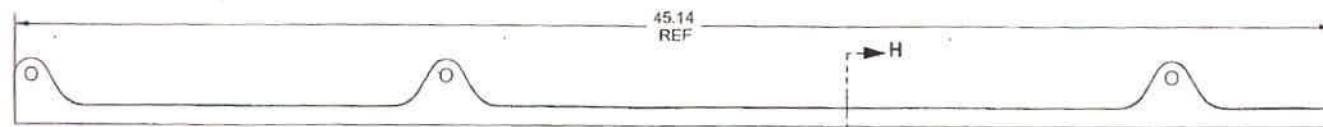
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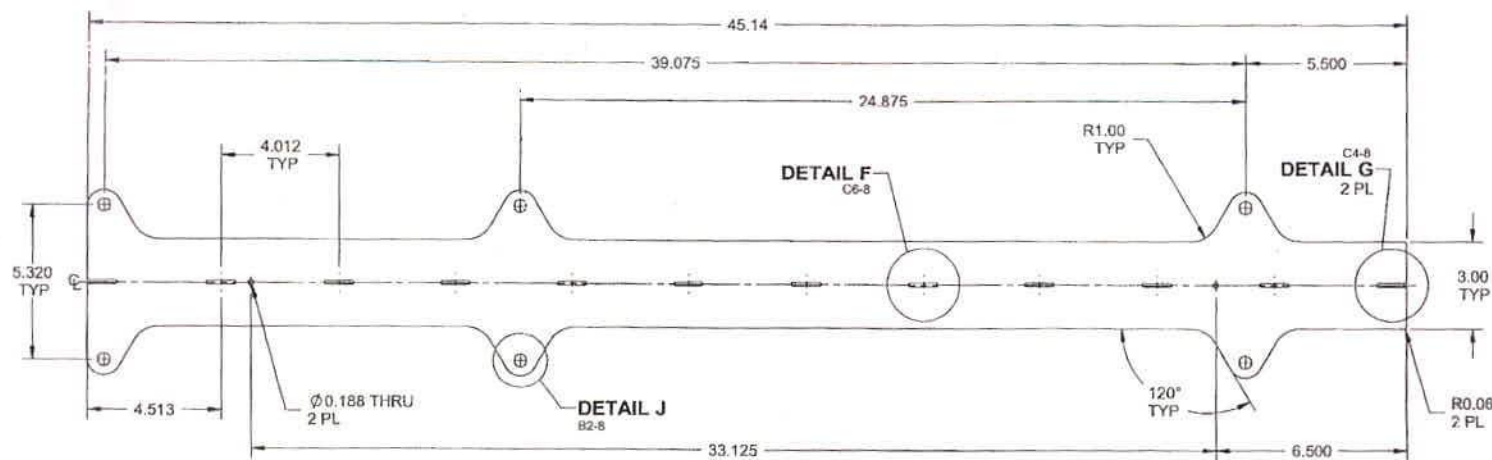




74825



**D3805-7 PLATE**  
(MAKE FROM D3805-7F)



**D3805-7F PLATE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

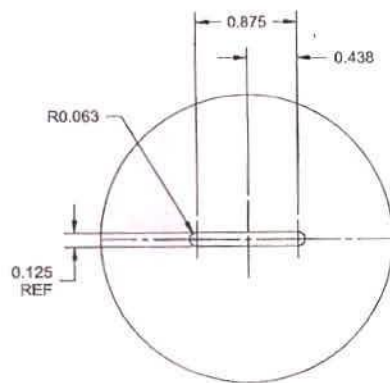
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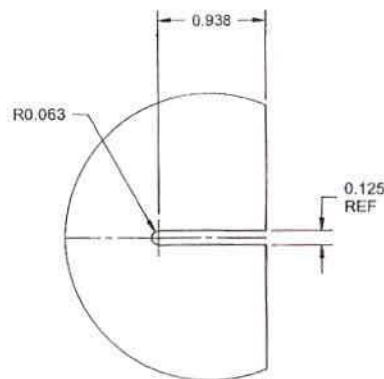
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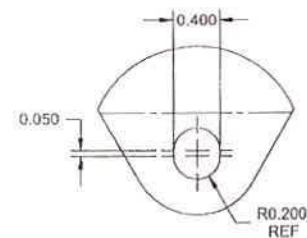
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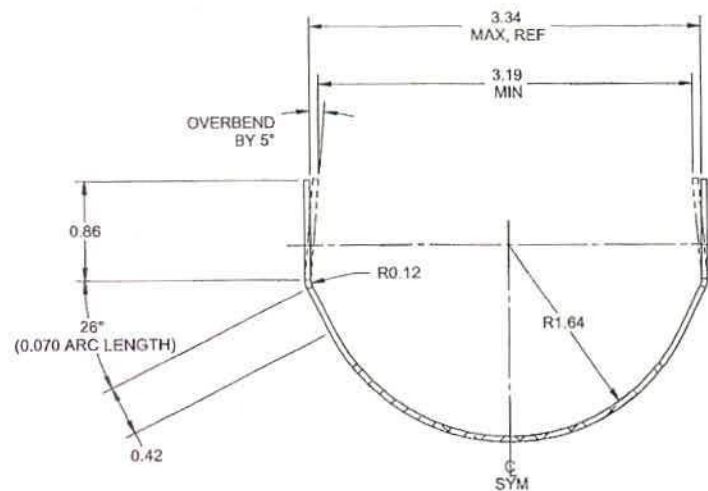
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SLOT DETAIL TYP  
SCALE 4X  
C5-4  
C5-5  
C4-6  
C4-7



**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X  
C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X  
B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X  
D3-4  
D3-5  
D3-6  
D3-7

74940

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